

Work Order ID 60498

Tuesday, July 13, 2010 10:03:25 AM



Page 1

Item ID: D3199-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 7/13/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan:

PA

Date: 10-7-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: *C*

Prog Rev: *C*

304 . 040

Deburr if required

SATD

10-07-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-7-07

(33)

10-7-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60498

Tuesday, July 13, 2010 10:03:25 AM

Page 2

Item ID: D3199-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 7/13/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 24.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				count (x33)			
130  Small Fab Small Fab	Small Fab Memo Form as per dwg D3199	0.00 0.00		8B 10/08/03		(33)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81060803		count (x33)			

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Work Order ID 60498

Tuesday, July 13, 2010 10:03:25 AM

Page 3

Item ID: D3199-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 7/13/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

m 112588

Memo

0.00

Powder Coating

START TIME: *12:50*
OVEN TEMPERATURE: *320°*
FINISH TIME: *1:20*

33. BR 10-8-5

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

m 10 08 05 (33)

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10/8/6 SP (33)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 60498

Tuesday, July 13, 2010 10:03:25 AM

Page 4

Item ID: D3199-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 7/13/2010 Start Qty: 24.00

Required Date: 7/20/2010 Req'd Qty: 24.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/09 *[Signature]*

MF 10-8-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 13, 2010 10:03:30 AM

Page 1

Work Order ID: 60498

Parent Item: D3199-1

Parent Item Name: Bracket




Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
IPP Rev:D As per Rev B 06-11-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	52.7173	0.099	2.501053	3.3	7-10-27	

Location

Loc Qty

Loc Code

MAT	49.2708
114574	49.2708
MAT20	3.4465
112885	2.7475
113062	0.699

114574

33

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

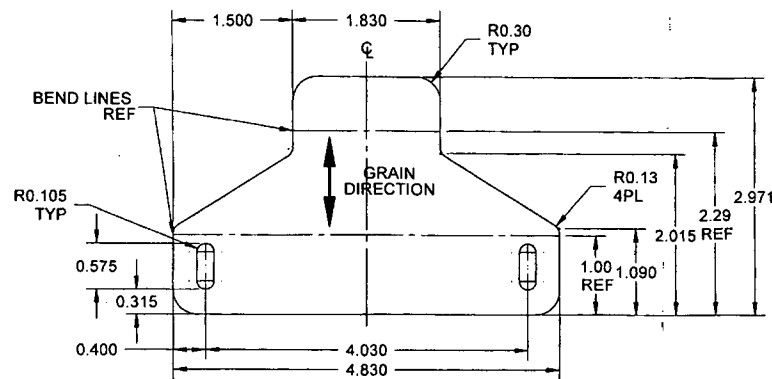
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

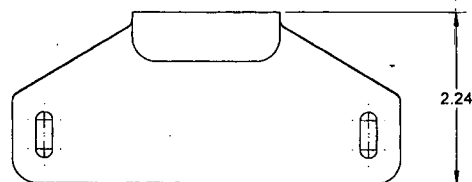
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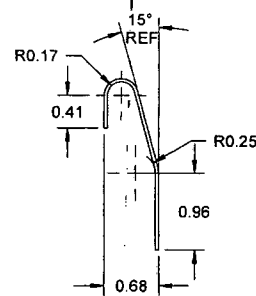
NOTE: Date & initial all entries



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60928

BS-0-7-13

RELEASED
2009-11-20

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.11 lbs

C	ADD -3/4 PART (SHEET 2-4)	CB	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>97</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3199 TITLE BRACKET SHEET 1 OF 4 SCALE NTS <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	<i>97</i>		
CHECKED	<i>97</i>		
MFG. APPR.	<i>97</i>		
APPROVED	<i>97</i>		
DE APPR.	<i>97</i>		
DATE	09.11.19		

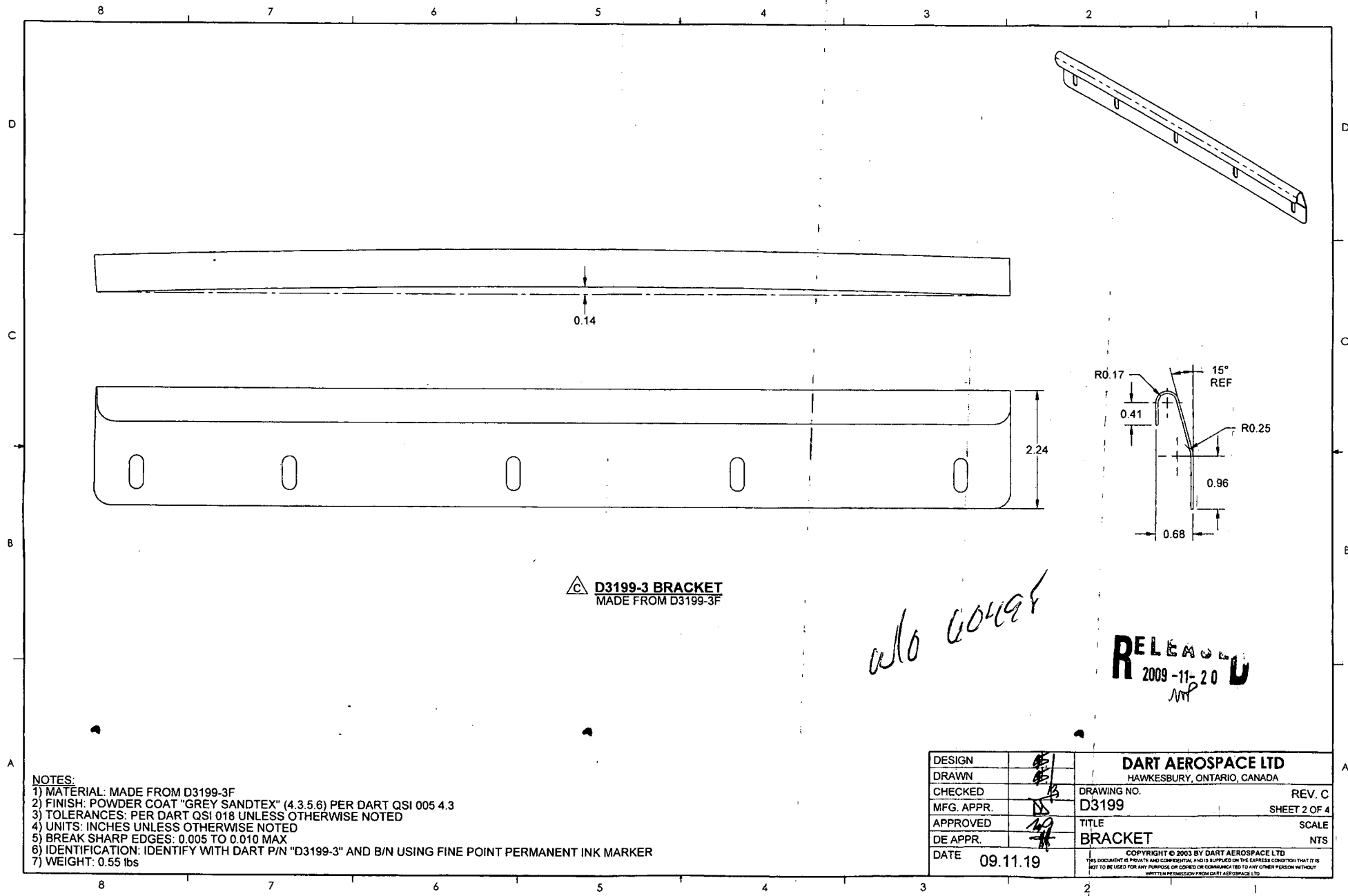
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3199-3 BRACKET
MADE FROM D3199-3F

also 60497

RELEASED
2009-11-20
MP

NOTES:

- 1) MATERIAL: MADE FROM D3199-3F
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.55 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3199	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.11.19	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR TESTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

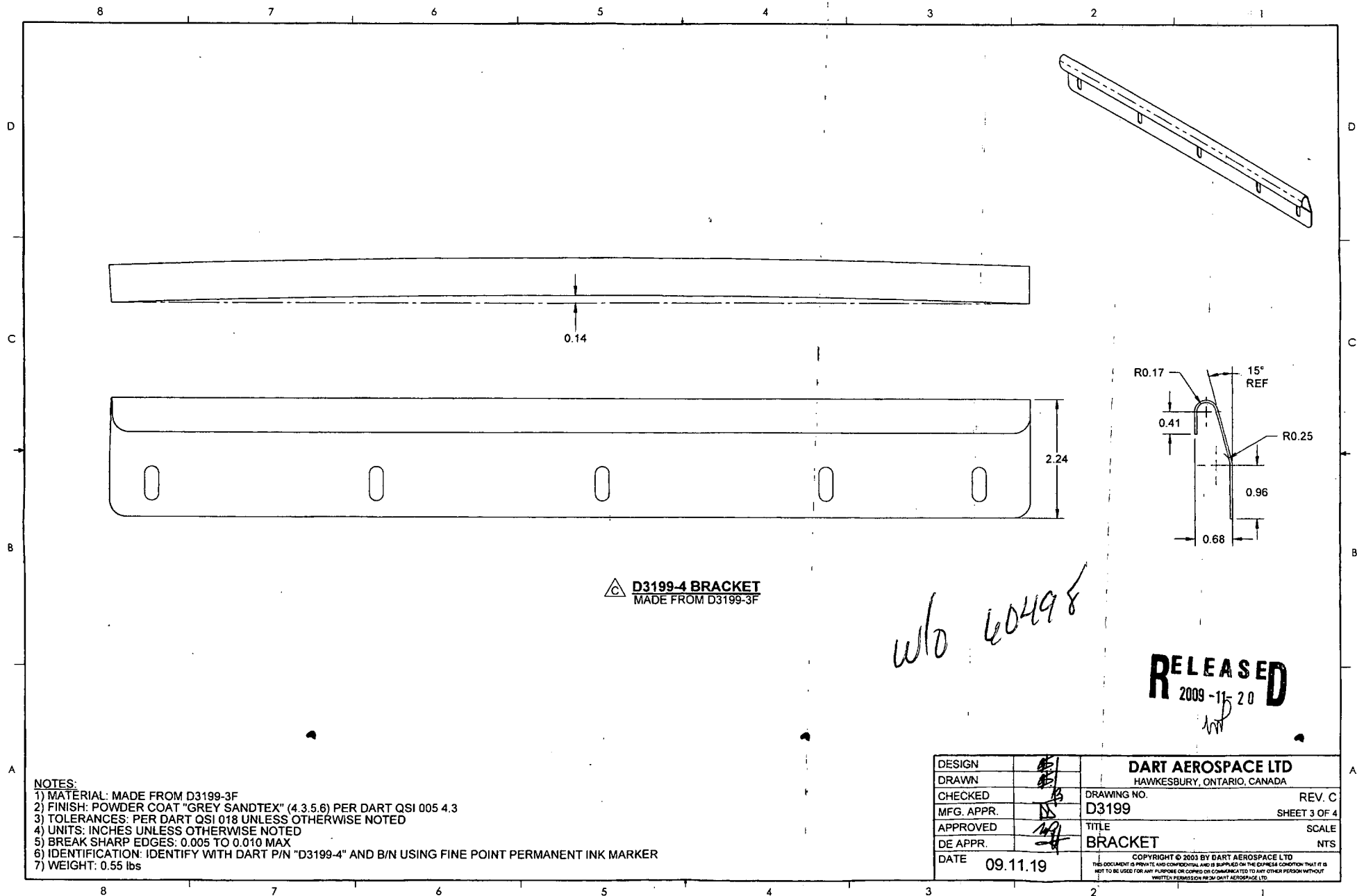
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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

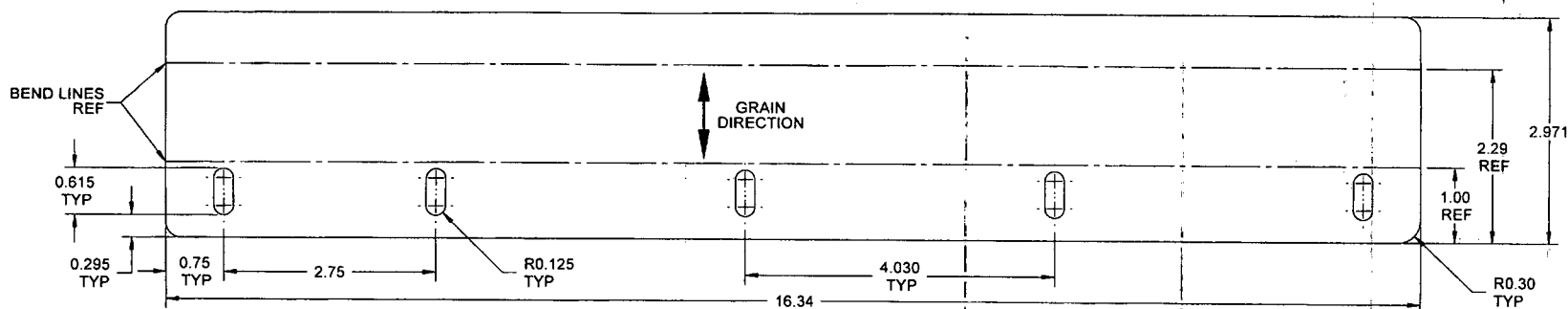
C

B

B

A

A



D3199-3F FLAT PATTERN

w/o 60498

RELEASED
2009-11-20
W.D.

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.55 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3199	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.11.19	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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